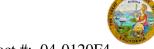
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-002519 Address: 333 Burma Road **Date Inspected:** 14-May-2008

City: Oakland, CA 94607

Project Name: SAS Superstructure **OSM Arrival Time:** 1400 **OSM Departure Time:** 2330 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes No N/A **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes N/A **Delayed / Cancelled:** No

34-0006 **Bridge No: Component: OBG** Deck Panels

Summary of Items Observed:

CALTRANS Quality Assurance (QA) Inspector, Erik Prue was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Tower Bay 3, New OBG Bay 1: QA inspector performed ultrasonic testing (UT) verification before ZPMC Quality Control (QC) UT inspections on partial penetration joints of deck panels DP-080-001 weld joints 9 & 10, DP085-001 weld joint 3, and DP490-001 weld joint 3. QA UT inspected 15% of the total weld length of weld joints listed above. QA Inspector found lack of penetration indications that results in depth of penetration less than the minimum of 9.6 mm required on weld joints for deck panels DP080-001 and DP490-001. Area inspected by QA UT Inspector for DP085-001 contained no areas of depth of penetration less than the required 9.6 mm. QA inspector performed ultrasonic testing (UT) verification after ZPMC Quality Control (QC) UT inspection on partial penetration joints of the deck panel DP-018-002 to the U-Rib weld joints 7 & 8. QC UT inspected 15% of the total weld length of each weld joint. QA UT Inspector inspected 100% of required 15% QC UT inspection per weld joint. QA UT Inspector verified ZPMC QC UT findings of no depth of penetration less than the required 9.6 mm. For details on UT inspections see modified TL-6027 UT Inspection reports dated 14 May, 2008.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)





Summary of Conversations:

No signifigant conversations this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 858 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer